



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2563

Job Sheet 202224



Part No: D2563

Job Qty: 6 pcs

Part Name: Step Weldment Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/19

Job Tracking No:

Due Date: 11/1/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP Rev:G 02.07.31 Re-format Location RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	6 pcs	11/1/19		0.00	12.00	Large Fab - 1		SLA
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	6 pcs	11/1/19		0.00	0.00	QC 9 - 10		EL
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	6 pcs	11/1/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S231944



Part: D2563

Job No: 202224

Serial No/Batch: S231944

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/18/19

Plex 10/22/19 1:46 PM Dart.lajeunesse.marie

130 Handfinish - 1-1 Chemical-B4B	6 pcs	11/1/19	0.00	1.61	QC 5 - 9	
					QC 5 - 50	CL
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					Handfinish - 1 - 1 - B4B	BEB 19-11-19
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
140 QC 7	6 pcs	11/1/19	0.00	0.00	Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
					QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	DAS
					QC 7 - 68	NOV 20 2019 68
					QC 7 - 50	9-89
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	

150	Large Fab - Welded Assy-2-B4B	6 pcs	11/1/19	0.00	8.82	QC 7 - 79	
						Large Fab - 1 - B4B	
						Large Fab - 10 - B4B	SL
						Large Fab - 2 - B4B	
						Large Fab - 3 - B4B	
						Large Fab - 4 - B4B	
						Large Fab - 5 - B4B	
						Large Fab - 6 - B4B	
						Large Fab - 7 - B4B	
						Large Fab - 8 - B4B	
						Large Fab - 9 - B4B	
						Large Fab - 11 - B4B (Various)	
						Large Fab - 12 - B4B	
160	QC 10	6 pcs	11/1/19	0.00	0.00	QC 10 - 10	
						QC 10 - 18	
						QC 10 - 24	
						QC 10 - 43	
						QC 10 - 50	GZ
						QC 10 - 58	
						QC 10 - 9	
						QC 10 - 68	
170	QC 5	6 pcs	11/1/19	0.00	0.00	QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	GZ
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
175	Handfinish - 2-1 Pressure-B4B	6 pcs	11/1/19	0.00	1.61	Handfinish - 2 - 1 - B4B	BEB 19-11-21
						Handfinish - 2 - 2 - B4B	
						Handfinish - 2 - 3 - B4B	
						Handfinish - 2 - 4 - B4B	
180	Powdercoat - 1 White GI(A)-B4B	6 pcs	11/1/19	0.00	1.00	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	BR 19-11-25.
						Powdercoat - 4 - B4B	
190	Handfinish - 3-1- WingWalk-B4B	6 pcs	11/1/19	0.00	1.61	Handfinish - 3 - 1 - B4B	ML 19-11-26
						Handfinish - 3 - 2 - B4B	
						Handfinish - 3 - 3 - B4B	
						Handfinish - 3 - 4 - B4B	
						Handfinish - 3 - 5 - B4B	
200	QC 3	6 pcs	11/1/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	

				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	DAS
				QC 3 - 40	NOV 2 8 2019 40
				QC 3 - 19	9-89
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
210	Packaging 3-1 - Stock - B4B	6	11/1/19	0.00 0.00	Packaging 3 - 1 - B4B
		pcs			Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
220	QC 21 - SA	6	11/1/19	0.00 0.00	QC 21 - SA - 21
		pcs			QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - (Weld per dwg A/R Aluminum rod Batch: <i>W2107</i> 1-Cut D2244 to 89.70" at 34 deg as per dwg D2563 2-Deburr ends					
Descriptions: 3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343 4- Grind					

- 110 - (QC9- Inspect visual per QSI004- Fusion Welds)
120 - (QC5- Inspect part completeness to step on W/O)
130 - (Chemical Conversion Coat per QSI005 4.1)
140 - (QC7-Inspect Chemical Conversion Coat)
150 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Inspect for foreign object per QSI 024 2-Weld Remaining End cap as per Dwg D2563 using DT 8343 3-Grind
160 - (QC10- Inspect visual per QSI004- ground welds)
170 - (QC5- Inspect part completeness to step on W/O)
175 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Touch up Alodine as per QSI005
180 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: 12:50 DU: 7:30 FINISH: 1:00 MAR 86
190 - (Wing Walk as per dwg QSI005 4.4 Batch 5129693)
200 - (QC3- Inspect Part Finish)
210 - (Identify as per dwg & Stock Location: _____)
220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	6 pcs (1 ea)	100-Large Fab - Welded Assy-1	5081118
D2561	Lug	12 pcs (2 ea)	100-Large Fab - Welded Assy-1	5192591
D2564	Mounting Angle	12 pcs (2 ea)	100-Large Fab - Welded Assy-1	5165133/5229621
D2673-34	End Plate	6 pcs (1 ea)	100-Large Fab - Welded Assy-1	5192727
D2673-34	End Plate	6 pcs (1 ea)	150-Large Fab - Welded Assy-2- B4B	5210765

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D2244-116	6	119	0
	D2561	12	12	0
	D2564	12	11	0
	D2673-34	6	44	0
150-Large Fab - Welded Assy-2- B4B	D2673-34	6	44	0

Part Specifications

Specifications could not be found.

Plex 10/22/19 1:46 PM Dart.lajeunesse.marie

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)			
Description Work Order Deviation				Disposition			
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors				FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread			
Completed By				Lead hand / Supervisor			
				QC / QA Coordinator			